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TITLE: AUTOMATIC **WELDING** DEVICE FOR **BRANCH PIPE**
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INVENTOR-INFORMATION:

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ABSTRACT:

PURPOSE: To facilitate controlling of flat **welding** in the fayed parts of a main **pipe and a branch pipe** by fixing a torch to the **branch pipe** via a wearing device, an angle adjusting device and a carriage.

CONSTITUTION: When a pinion 18 is rotated by a motor 19, a carriage 15 begins to rotate around the axial line of a **branch pipe** 2. At this time, a lateral slider 14, a vertical slider 13 and a torch angle adjuster 12 are operated according to the rotating angles of the carriage 15 to set the aiming position and aiming angle of a **welding** torch 10. Further, according to the rotating angles of the carriage 15, the conditions such as the number

of
oscillations of weaving, the amplitude thereof, welding current,
voltage, speed
and the like are changed over and the butt parts of a main pipe 1 and
the
branch pipe 2 are welded. At this time, a main pipe oscillator 24 is
operated
in accordance with the control signals programmed beforehand in
accordance with
the rotating angles of the carriage 15 to control the welding
position from a
horizontal fillet welding position to roughly a flat position.

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